

Work Order ID 105977

105977

Page 1

August-28-13 11:47:48 AM

Item ID: D3914-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rib

Start Date: 8/27/13 Start Qty: 2.00

2
2

Cust Item ID:

Required Date: 8/28/13 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-08-29 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3914	C'

100

100

Large Fab

Memo

0.00

(8x)

CC 13-11-11

Large Fab

1- Cut tube as per dwg D3914
2- debur and remove identification markings

110

110

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

8x

DAS
43
8-89

13-11-11

120

120

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Batch v11

Memo

8x

DAS
43
8-89

13-11-11

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
				Centre Not Concentric to O/S <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
				Cracks <input type="checkbox"/>	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>			
				Crushed/Crimped <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
				Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>				
				Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
				Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>			
				Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>					
				Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
				Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					
				Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>					

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105977

Page 2

Item ID: D3914-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rib

Stop

NS2

Start Date: 8/27/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/28/13

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Quality Control

Memo

0.00

 RM 13/11/14
 MF
13-11-14

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
NCR No. _____				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend <input type="checkbox"/>		Grain <input type="checkbox"/>		Ovalized <input type="checkbox"/>		Pressure/Forced <input type="checkbox"/>			
Centre Not Concentric to O/S		BOM/Route <input type="checkbox"/>		Hardware <input type="checkbox"/>		Over/Under tolerance <input type="checkbox"/>		Temperature/Cure <input type="checkbox"/>			
Cracks		Broken/Damaged <input type="checkbox"/>		Inspection Incomplete <input type="checkbox"/>		Part Incorrect <input type="checkbox"/>		Weld <input type="checkbox"/>			
Crushed/Crimped		Burrs <input type="checkbox"/>		Instructions Incomplete/Unclear <input type="checkbox"/>		Part Lost/Missing <input type="checkbox"/>		Wrong Stock Pulled <input type="checkbox"/>			
Cuffs		Contamination <input type="checkbox"/>		Maintenance <input type="checkbox"/>		Part Moved <input type="checkbox"/>					
Heat Treat		Countersink <input type="checkbox"/>		Mislabeled <input type="checkbox"/>		Positioned Wrong <input type="checkbox"/>					
Inspection Strip in Tube		Cut Too Short <input type="checkbox"/>		Misread <input type="checkbox"/>		Power Loss/Surge <input type="checkbox"/>					
Ripples in Bend		Drill Holes <input type="checkbox"/>		Offset <input type="checkbox"/>		Other <input type="checkbox"/>					
Torque Waves in Extrusion		Drawing <input type="checkbox"/>		Out of Calibration <input type="checkbox"/>							
Turning Sequence		Finish <input type="checkbox"/>		Out of Sequence <input type="checkbox"/>							
Wave/Twist in Tube		Folio <input type="checkbox"/>		Outside Dimensions <input type="checkbox"/>							

Picklist Print

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Work Order ID: 105977

Parent Item: D3914-1

Start Date: 8/27/13

Required Date: 8/28/13

Parent Item Name: Rib

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
10.08.18 verified by:EC IPP Rev:B as per dwg revB DD
IPP Rev:C 11.01.18 chg qc5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	1,172.8397	8	16.842105		CC 13-11-11	

Location	Loc Qty	Loc Code
WA006	1172.839733	B126900 → 68.
123484	2.95828950	
125124	205.405667	
125575	122.882777	
M126039	241.593	
M126364	600	

NCR: Yes / No

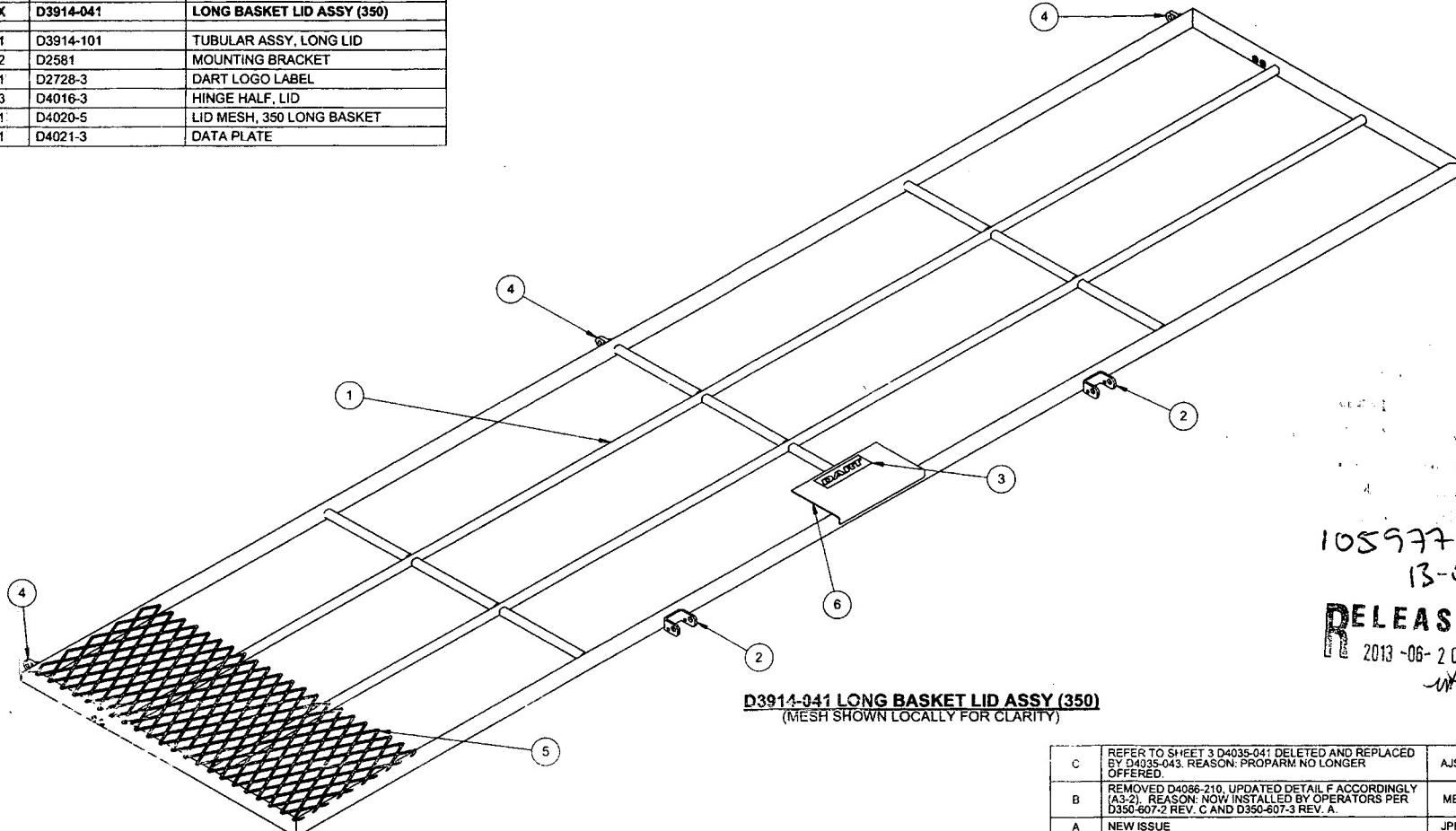
DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No.				Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
NCR No.				Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
				Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>
				Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		
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Training													
Unapproved													
FAULT CATEGORY													
Landing Gear				General									
Bending	Bend	Grain	Ovalized	Pressure/Forced									
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure									
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld									
Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled									
Cuffs	Contamination	Maintenance	Part Moved										
Heat Treat	Countersink	Mislabeled	Positioned Wrong										
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge										
Ripples in Bend	Drill Holes	Offset											
Torque Waves in Extrusion	Drawing	Out of Calibration											
Turning Sequence	Finish	Out of Sequence											
Wave/Twist in Tube	Folio	Outside Dimensions											

ITEM	QTY -041	P/N	DESCRIPTION
X	D3914-041		LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
5	1	D4020-5	LID MESH, 350 LONG BASKET
6	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

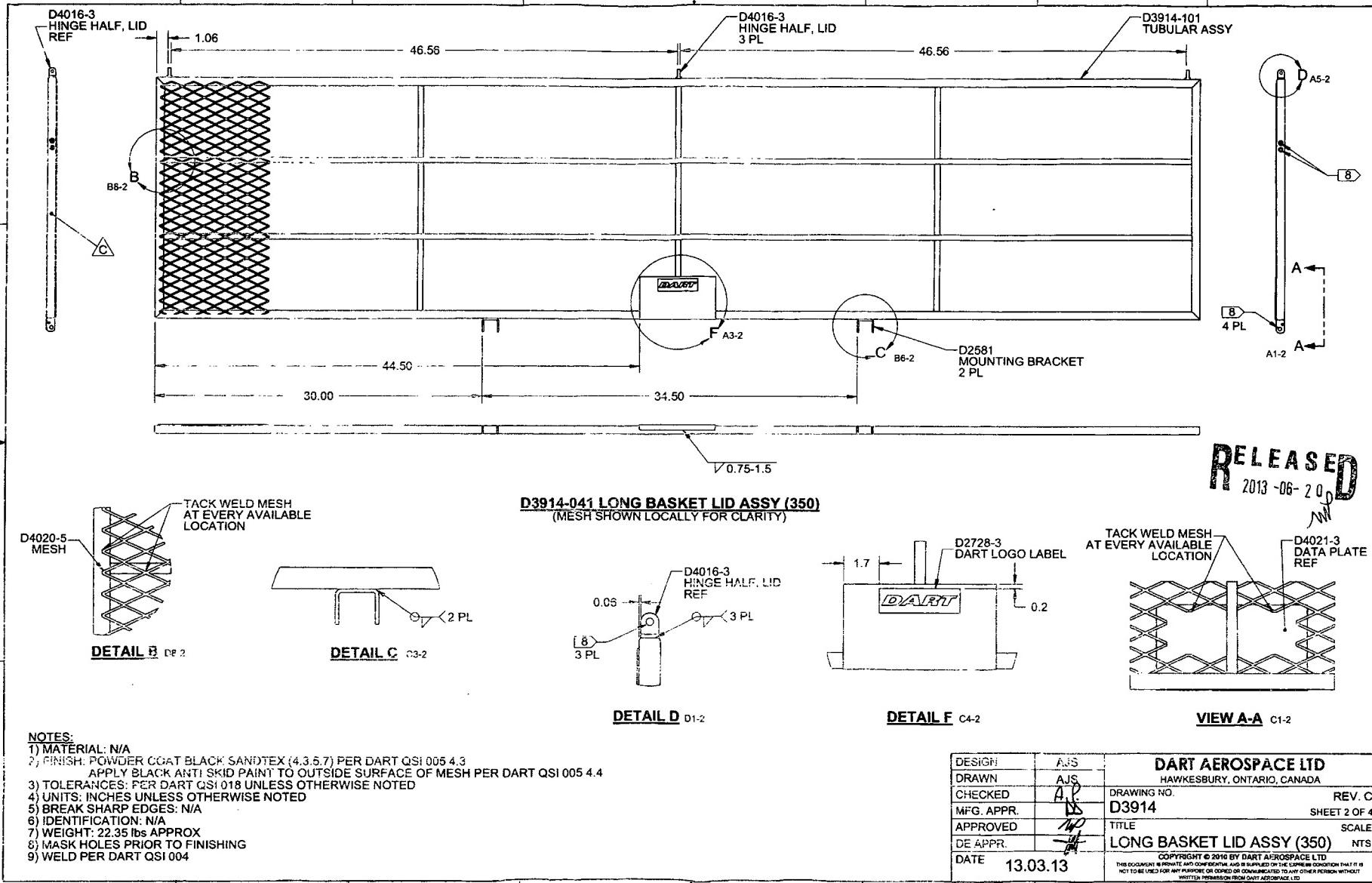
105977 MLS
13-08-29

RELEASED
2013-06-20
WP

C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROPARM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION		
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. C
CHECKED	A.P.	D3914	SHEET 1 OF 4
MFG. APPR.	N/A	TITLE	SCALE
APPROVED	N/A	LONG BASKET LID ASSY (350)	NTS
DE APPR.	N/A	COPYRIGHT © 2010 BY DART AEROSPACE LTD THE DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT MAY NOT BE REPRODUCED IN WHOLE OR IN PART, OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.03.13		



105977



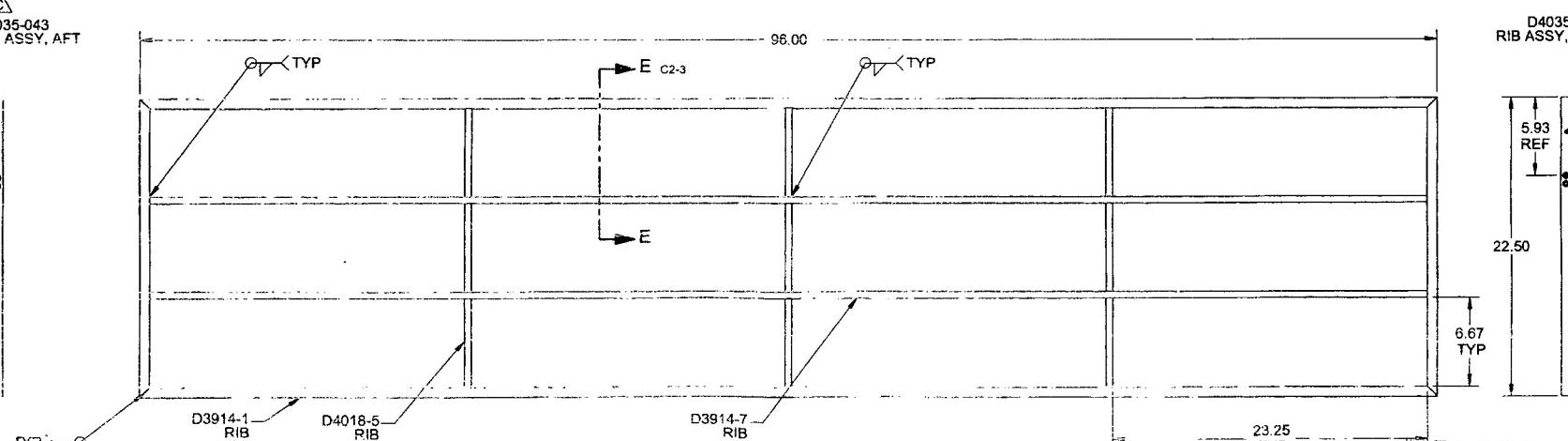
105977

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT

C



SECTION E-E CS-3

D4035-043
RIB ASSY, AFT5.93
REF

22.50

6.67
TYPRELEASED
2013-06-20
MP

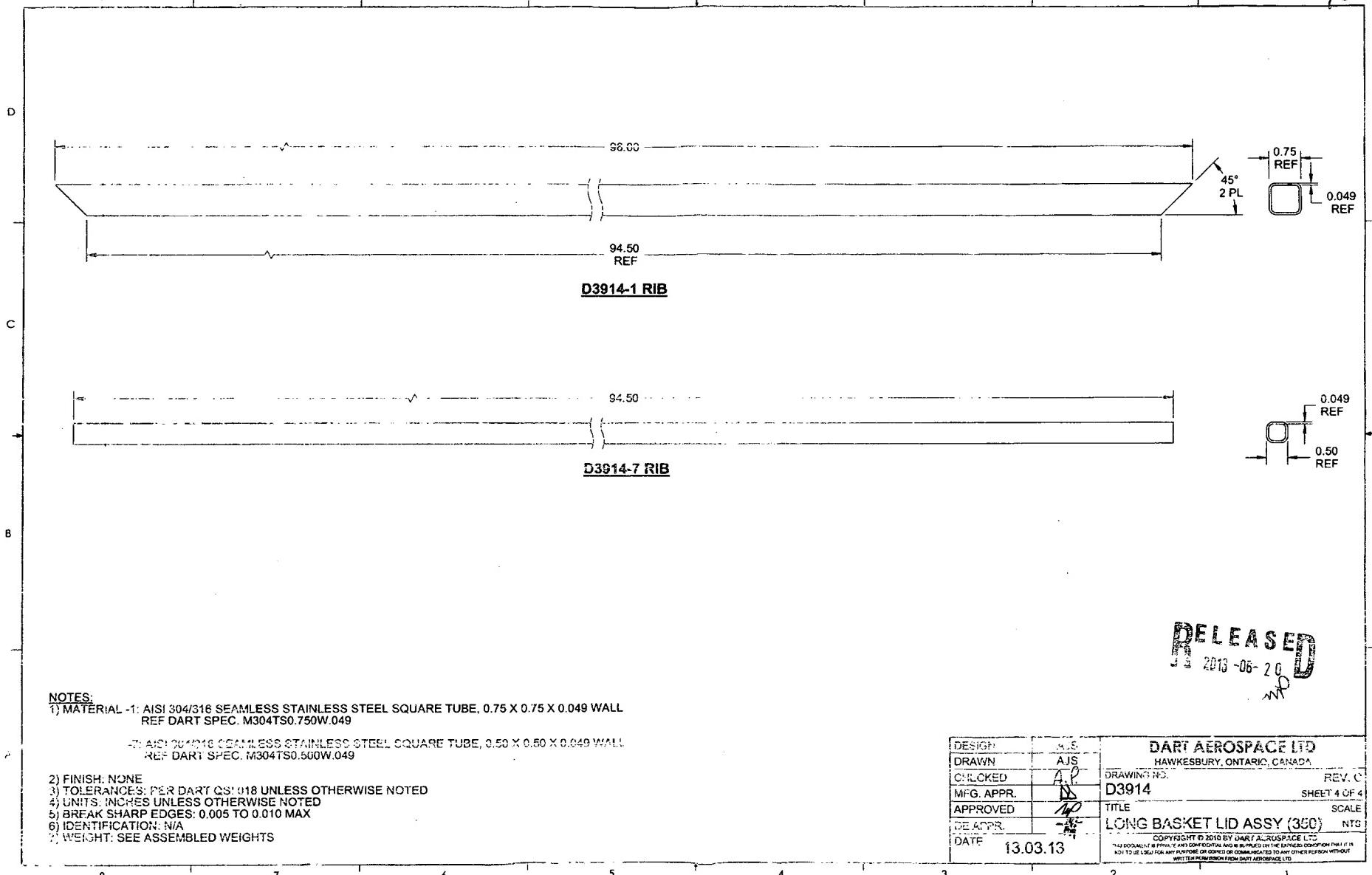
- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: P&P DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 14.10 lbs
 8) TOLERANCE FOR XX XX DIMENSIONS ±0.06 FOR D3914-101
 9) WELD PER DART QSI 004

DESIGN:	AS	DART AEROSPACE LTD	
DRAWN:	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED:	AP	REV. C	
MFG. APPR.	DA	DRAWING NO. D3914	
APPROVED:	MP	SHEET 3 OF 4	
DE APPR.	DA	TITLE: LONG BASKET LID ASSY (350) NTS	
DATE:	13.03.13	SCALE:	

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8 7 6 5 4 3 2 1

105977



DESIGN	A.S	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO.
MFG. APPR.	DS	REV. C
APPROVED	NP	SHEET 4 OF 4
DE APPR.	NP	TITLE
DATE	13.03.13	SCALE
LONG BASKET LID ASSY (350) NTS		
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